
Standard Specification for

The Evaluation of Blast-Cleaned Steel Surfaces

AASHTO Designation: M 271-02



American Association of State Highway and Transportation Officials
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1. SCOPE

- 1.1. This standard established minimum levels to which steel surfaces are to be cleaned by blast methods in preparation for painting.
- 1.2. The standards are appropriate only for use with surfaces cleaned by the methods described.
- 1.3. The values stated in SI units are to be regarded as the standard.

2. REFERENCED DOCUMENTS

- 2.1. *The Society for Protective Coatings Specification:*¹
 - SSPC-VIS 1-89, Visual Standard for Abrasive Blast Cleaned Steel

3. DEFINITIONS

- 3.1. *non-metallic abrasive blasting*—the cleaning of steel surfaces by mechanical removal of rust and other contaminants by use of an airborne stream of particles of non-metallic abrasive, such as mineral slag or garnet.
 - 3.1.1. Other definitions relating to blast cleaning are to be found in SSPC-VIS-1.
- 3.2. *shotblasting*—the cleaning of steel surfaces by mechanical removal of rust and other contaminants by use of a stream of cast steel particles thrown against the surface.
 - 3.2.1. *commercial*—the degree of surface cleaning appropriate for the application of oil alkyd paint systems.
 - 3.2.2. *near white*—the degree of surface cleaning appropriate for the application of zinc paint systems.

4. PROCEDURE

- 4.1. The degree to which the surface is to be cleaned will be established by the specifying agency.
- 4.2. Blast-cleaned surfaces are to be evaluated by use of SSPC-VIS-1.